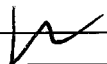
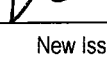


Date: Thursday, 9/11/2008 8:36:48 AM  
 User: Chantal Lavoie

## Process Sheet

|  |  |
|--|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : SADDLE BILLET (6061)                 |
| <b>Job Number</b> : 41962  |  |
| <b>Estimate Number</b> : 12482   |  |
| <b>P.O. Number</b> :   | <b>Part Number</b> : D6102013                              |
| <b>This Issue</b> : 9/11/2008 <b>S.O. No.</b> :  | <b>Drawing Number</b> : D6102 REV D                        |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS   | <b>Drawing Revision</b> : D                                |
| <b>Previous Run</b> : 35951  | <b>Material</b> :  |
| <b>Written By</b> :                 | <b>Due Date</b> : 9/26/2008 <b>Qty:</b> 50 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> :  |  |
| <b>Comment</b> : Est Rev:A New Issue 06-07-03 JLM  |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|

Comment: Issue P/O: 7144

- a) Description: Aluminum Billet
  - b) 7.000" x 6.500" x 2.000" thick
  - c) Tolerance on all dimensions is +0.06/0.00
  - d) Grain direction along 6.500" length
  - e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
- Material release certificate is required

C208/09/11

(50)

|     |           |                     |
|-----|-----------|---------------------|
| 2.0 | D6102013P | 6061-T6 7.0x6.5x2.0 |
|-----|-----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)  
 6061-T6 7.000"x6.500"x2.000"

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C 8/9/25 (50)

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK  
 Check certification to Dwg D6102 for compliance

S 08/10/02 (50)

center

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

C 8/10/02 (50)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Thursday, 9/11/2008 8:36:48 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 41962

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/10/08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

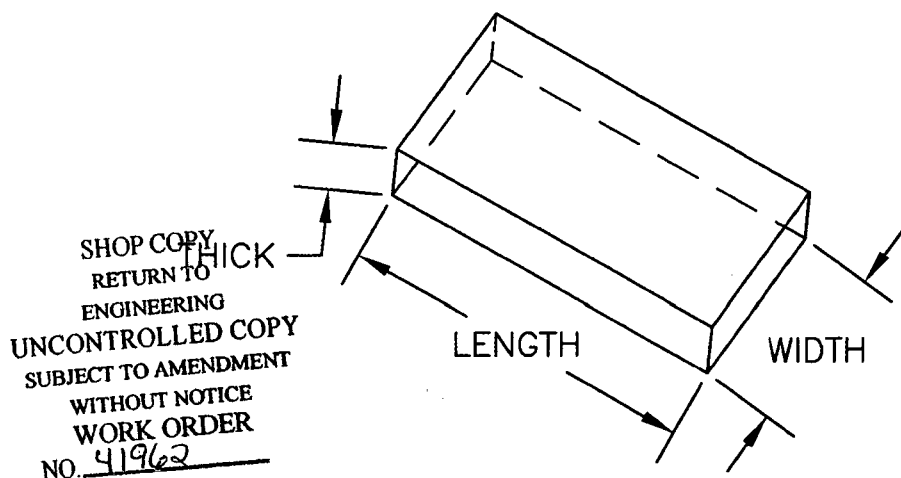
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>#      | DRAWN BY<br>PH | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>CP    | APPROVED<br>#  | DRAWING NO.<br>D6102                              | Rev. D<br>SHEET 1 OF 1 |
| DATE<br>06.06.30 |                | TITLE<br>SADDLE BILLET, 6061                      | SCALE<br>NTS           |
| A                | 01.03.30       | NEW ISSUE   |                        |
| B                | 03.10.20       | ADD D6102-005/-007/-009                           |                        |
| C                | 04.08.25       | ADD D6102-010/-011                                |                        |
| D                | 06.06.30       | ADD D6102-013                                     |                        |

## SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

| Part No.  | Alloy                                    | Length | Width  | Thick | Grain Direction     |
|-----------|--|--------|--------|-------|---------------------|
| D6102-001 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.880  | 6.250  | 2.000 | Along 7.880 Length  |
| D6102-003 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.000  | 6.250  | 2.000 | Along 6.000 Length  |
| D6102-005 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 47.85  | 15.250 | 1.000 | Along 47.85 Length  |
| D6102-007 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.500  | 7.000  | 2.500 | Along 7.500 Length  |
| D6102-009 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 11.000 | 6.000  | 5.000 | Along 11.000 Length |
| D6102-010 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.950  | 8.250  | 2.500 | Along 7.950 Length  |
| D6102-011 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500  | 8.250  | 2.500 | Along 6.500 Length  |
| D6102-013 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500  | 7.000  | 2.000 | Along 6.500 Length  |

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# TEST CERTIFICATE



Hulamin Limited Reg. No. 1940/013924/05 VAT Reg. No. 4063146504  
HEAD OFFICE: Moses Mphahle Rd, Pietermaritzburg 3201, P.O. Box 24, Pietermaritzburg 3203, South Africa  
Telephone: +27 33 395 6911 Telefax: +27 33 394 6335

|   |  |  |
|---|--|--|
| <b>BUYER:</b><br>EMPIRE RESOURCES INC<br>10th FLOOR<br>1 PARKER PLAZA<br>FORT LEE | <b>Shipping File No :</b> UR33215<br><b>Lot No :</b> 03/12/392R2<br><b>P/List No :</b> 2/618991<br><b>Release No :</b> | <b>Product :</b> 2" X 48.5" X 144.5" PLATE 6061, T651<br><b>Dimension :</b> 2" X 48.5" X 144.5"<br><b>Alloy - Temper :</b> 6061 - T651 |
|   | <b>Cust Order No :</b> 3516-P.R126851<br><b>HULAMIN Order No :</b> 144547E<br><b>Item Part :</b> 1/1                   | <b>Certificate No :</b> 0712LB5841<br><b>Cust Ref/Part No :</b><br><b>Combined P/List No :</b>   |

Case No :

## MECHANICAL TEST RESULTS

| Lot No.     | Cast No. | Metal Id | Alloy | Spec No    | Mechanical Properties |              |                    |            |                      |                       |           |
|-------------|----------|----------|-------|------------|-----------------------|--------------|--------------------|------------|----------------------|-----------------------|-----------|
|             |          |          |       |            | Yield Strength (Ksi)  | UTS (Ksi)    | Elongation A50 (%) | Earing (%) | Test Date            | Gauge Length (Inches) | Bend Test |
| Spec        |          |          |       | Min<br>Max | 34.8<br>42.0          | 42.0<br>48.4 | 10<br>13           |            |                      |                       |           |
| 03/12/392R2 | SBRH     | 99578037 | 6061  | 1<br>2     | 40.7<br>40.6          | 48.6<br>48.4 | 13<br>13           |            | 17/12/07<br>17/12/07 | 02<br>02              |           |

## CHEMICAL COMPOSITION

|     | Cast No. | Alloy | Si (%) | Fe (%) | Cu (%) | Mn (%) | Mg (%) | Cr (%) | Zn (%) | Ti (%) | Each (%) | Total (%) |
|-----|----------|-------|--------|--------|--------|--------|--------|--------|--------|--------|----------|-----------|
| Min |          |       | 0.40   |        | 0.15   |        | 0.8    | 0.04   |        |        |          |           |
| Max |          |       | 0.5    | 0.7    | 0.40   | 0.15   | 1.2    | 0.35   | 0.25   | 0.35   | 0.05     | 0.15      |
|     | SBRH     | 6061  | 0.68   | 0.38   | 0.28   | 0.07   | 1.00   | 0.18   | 0.06   | 0.02   |          |           |

CONFORMS TO: AMS 900-A-250/11, ASTM B 209-86, ASME SB-203 AND AMS 4027M

WE HEREBY CERTIFY, THAT THE MATERIAL DESCRIBED ABOVE HAS BEEN TESTED AND COMPLIES WITH THE TERMS OF THE ORDER CONTRACT. THE INSPECTION RESULTS INDICATED IN THE CHEMICAL COMPOSITION HAVE BEEN OBTAINED FROM CAST ANALYSIS.

Dr. A. Pritchard (HEAD OF CHEMICAL TESTING)

Ver 2.2.6

V. Mandam (HEAD OF PHYSICAL TESTING)

Printed Date : Sunday 30 December 2007

Empire Resources, Fort Lee

1 of 1

CASTLE METALS CORP.  
DATE RCVD 2/18/08  
IAC 8641  
APPROVED BY u

02-18-'08 13:04 FROM-

T-822 P021/021 F-299

